

METHOD AND APPARATUS FOR CONTROLLING FILM THICKNESS OF COATED STEEL

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Abstract of JP59057109

PURPOSE: To control a film thickness into a uniform thickness, by regulating the temps. of the corresponding sections of a split type extrusion die on the basis of the measuring value in the entire peripheral direction of the film thickness of a coated plastic resin layer to control the resin emitting amount from each section.

CONSTITUTION:In coating a plastic resin coated steel pipe, the film thickness of a coating layer is measured respectively directly after etching resistant layer coating-water cooling and directly after protective layer coating-water cooling by ultrasonic thickness meters 5, 5. That is, four ultrasonic probes 5a-5d are provided around the steel pipe P at 90 deg. intervals to be rotated 1/4 and the film thickness of the plastic resin layer applied to the steel pipe P is measured by using jet type water columns 50a-50d as couplings. The film thickness measuring values in the entire peripheral direction thus obtained by the probes 5a-5d are inputted to an information treating part 6 along with probe position angle pulses while the temp. information of the coating R is also measured by a surface thermometer 7 to be inputted to the treating part 6 where operation treatment is performed to carry out the compensation of the measured film thickness value and a real film thickness value is obtained.

